

# Work Order ID 82374

March-30-12 7:42:55 AM

**\*82374\***

Page 1

Item ID: D2665-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Saddle, LH Fwd Aft Out 206  
Start Date: 29/03/2012 Start Qty: 8.00 **\*8\*** Cust Item ID:  
Required Date: 12/04/2012 Req'd Qty: 8.00 **\*8\*** Customer:  
Reference:

Approvals: Process Plan: MLJ Date: 12/03/30 Tooling: Date: Run Start **\*NR1\***  
QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2665	Rev D

100	HAAS CNC VERTICAL MACHINING #1	0.00							
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**\*100\***  
HAAS 1  
HAAS CNC vertical machine #1

Memo  
Program batch number.1- Inspect part number and batch number are programmed correctly.2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

8 1 *OK/PTO 12/04/12*

110	CONVENTIONAL MILLING MACHINE	0.00							
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**\*110\***  
Mill Conv  
Conventional Milling Machine

Memo  
Machine Keyway and inspect per attached dimension sheet

8 *OK 12/04/12*

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
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**\*120\***  
QC  
Quality Control

Memo

8 *OK 12/04/12*

W/O: 82374

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2665-1 PAR #: \_\_\_\_\_ Fault Category: Machining NCR: Yes No DQA: OK Date: 12/04/27  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 12/4/27

NCR: 121384		WORK ORDER NON-CONFORMANCE (NCR) 176.29						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/04/20	100	entered wrong offset for T20. so in doing that the blank is faced too thin. RL operator error	<u>W</u> 12.04.25	-Scrap + Dash AND Replace 3 81924	F.K. 12/04/20	SL 12-04-25	<u>W</u> 12.04.25	<u>S</u> 12/04/24
		reject qty 1						

NOTE: Date &amp; initial all entries

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Page 2

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 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Inspect parts - second check 0.00

**\*130\***

QC

Memo

0.00

Quality Control

22 12-04-25

140 Chemical Conversion Coat per QSI005 4.1 0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

8 7/6 12-4-25

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

**\*150\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

10:50

3200 F

11:20

8X 11-2 12/04/25

M121134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82374

March-30-12 7:42:55 AM

**\*82374\***

Page 3

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 Required Date: 12/04/2012 Req'd Qty: 8.00 **\*8\*** Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

170	Identify as per dwg & Stock Location: <b>ST 436</b>	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									

180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

12/4/25  
12-01-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-30-12 7:43:00 AM

Page 1

Work Order ID: 82374

\*82374\*

Parent Item: D2665-1

\*D2665-1\*

Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house processEC  
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	33.0000	1	8			

\*D6101-003\*

Saddle Billet, 7075

\*\*

Location	Loc Qty	Loc Code
MAT040	26	
73775	2	
73780	7	
78599	10	
80765	0	
MAT041	13	
79587	4	
80765	9	
MAT042	-7	
MAT044	1	
73769	1	

81924

8

Fk 12/04/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE ,	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	82374
<b>Description:</b> 206 Saddle, Outboard, Left side		<b>Part Number:</b>	D2665-1
<b>Inspection Dwg:</b> D2665 <b>Rev:</b> D <b>DSK:</b> <b>Rev:</b>		Page 1 of 1	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.121	.123	.123	.123	.123
B	0.100	0.140		.130	.124	.124	.120	.120
C	1.125	1.145		1.136	1.135	1.140	1.139	1.1384
D	0.615	0.685		.660	.660	.660	.660	.660
E	0.240	0.260		.255	.257	.257	.257	.257
F	1.313	1.343		1.327	1.328	1.328	1.328	1.328
G	0.210	0.230		.223	.226	.226	.224	.224
H	0.100	0.180		.132	.132	.132	.133	.133
I	2.470	2.510		2.495	2.495	2.495	2.491	2.491
J	1.565	1.585		1.575	1.575	1.577	1.579	1.576
K	0.235	0.240		.238	.237	.237	.237	.237
L	0.100	0.120		.110	.110	.110	.108	.108
M	0.990	1.010		.998	1.000	1.000	1.000	1.000
N	0.510	0.515		.512	.512	.512	.512	.512
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500
R	0.312	0.318		.313	.313	.313	.314	.314
S	0.315	0.322		.315	.315	.315	.316	.316
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500
U	1.357	1.367		1.362	1.362	1.367	1.362	1.362
V	0.787	0.807		.795	.795	.795	.795	.795
W	0.540	0.560		.552	.551	.550	.548	.550
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679
Y	0.256	0.262		.257	.257	.257	.259	.259
Z	0.912	0.932		.926	.926	.926	.922	.922
AA	0.490	0.510		.505	.504	.505	.500	.500
AB	0.178	0.198		.188	.188	.188	.188	.188
AC								
AD								
AE								
Accept/Reject								

<b>Measured by:</b> RF/TW	<b>Date:</b> 12/04/21
<b>Audited by:</b> JL	<b>Date:</b> 12/04/25
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	AA

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>82374</b>
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b>	<b>D2665</b>
<b>Inspection Dwg:</b> D2665	<b>Rev:</b> D	<b>DSK:</b>	<b>Rev:</b>
			<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

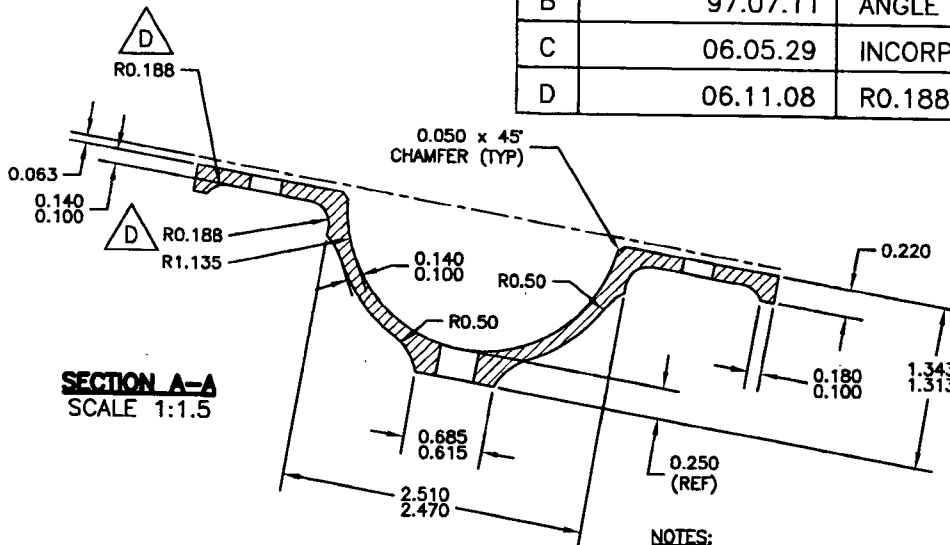
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	27	38	4	5
A	0.100	0.140		.123	.123	.123		
B	0.100	0.140		.120	.120	.120		
C	1.125	1.145		1.138	1.138	1.138		
D	0.615	0.685		.660	.660	.660		
E	0.240	0.260		.252	.252	.257		
F	1.313	1.343		1.328	1.328	1.328		
G	0.210	0.230		.225	.224	.225		
H	0.100	0.180		.136	.137	.137		
I	2.470	2.510		2.495	2.493	2.493		
J	1.565	1.585		1.581	1.576	1.576		
K	0.235	0.240		.237	.238	.237		
L	0.100	0.120		.110	.110	.110		
M	0.990	1.010		1.000	1.000	1.000		
N	0.510	0.515		.512	.512	.512		
O	5.990	6.010		6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500		
R	0.312	0.318		.315	.315	.315		
S	0.315	0.322		.316	.316	.316		
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U	1.357	1.367		1.362	1.362	1.362		
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Z	0.912	0.932		.922	.923	.922		
AA	0.490	0.510		.498	.498	.499		
AB	0.178	0.198		.188	.188	.188		
AC								
AD								
AE								
Accept/Reject								

<b>Measured by:</b>	<i>DX</i>	<b>Date:</b>	<i>12/04/22</i>
<b>Audited by:</b>	<i>SL</i>	<b>Date:</b>	<i>12/04/25</i>
<b>Prototype Approval:</b>		<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	<i>M</i>

**DART**

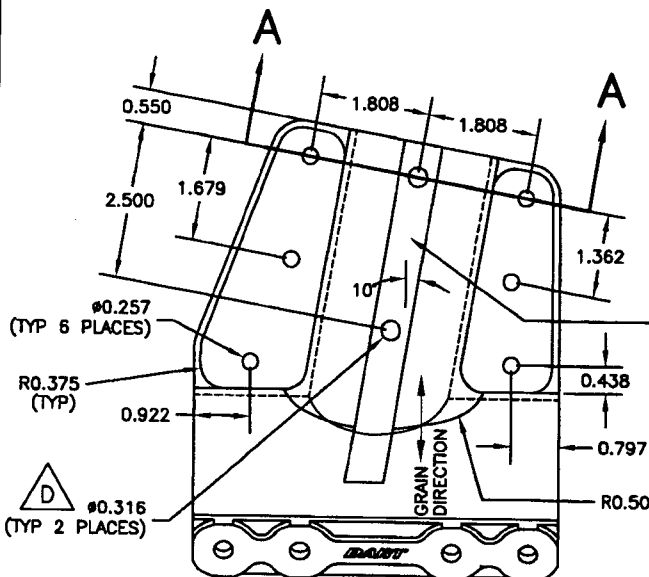
DESIGN <b>#</b>	DRAWN BY <b>CB</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <b>PH</b>	APPROVED <b>#</b>	DRAWING NO. D2665	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE FWD OUTSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	



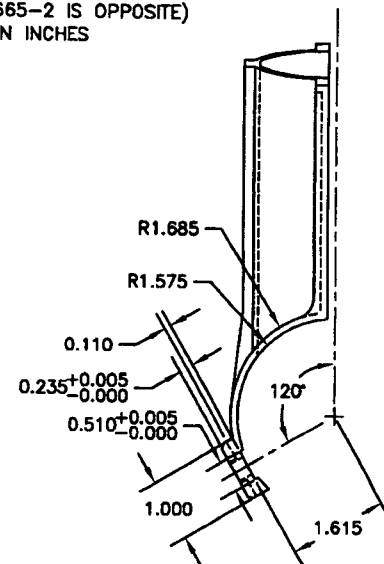
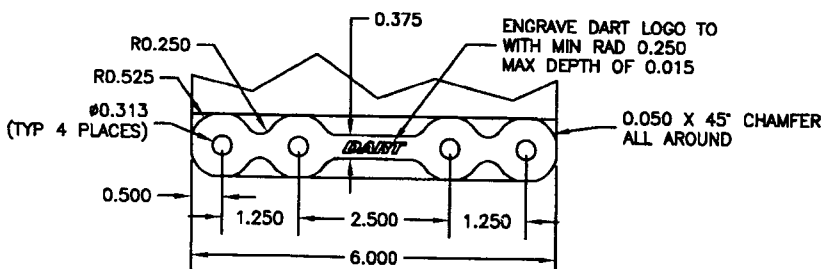
**RELEASED**  
07.02.12  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
82374MCS  
12/03/30

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART  
NUMBER AND  
BATCH NUMBER  
TO MAX DEPTH  
OF 0.010 WITH  
MIN RADIUS  
OF 0.010

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